



Dart Aerospace Ltd.
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U/R

S/M
19/07/11

6F9540V00231
Job Sheet 197321



Part No: 6F9540V00231

Job Qty: 1 pcs

Part Name: AW169 Lower Cutter Installation Assembly



Part Weight: 0 lbs

Status: New

Job Created: 7/4/19

Job Tracking No:

Due Date: 12/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF16-692 DWG IIN-D169-841 REV D IPP REV:A 13.11.13 NEW ISSUE DD VERF:JLM

Ship Via:

POSITIVE RECALL

EFFECTIVE 19/07/11 AUTH S/M

RELEASED 9-89 DATE 20-09-30

Concession Required by QA release per 6CR21

Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Packaging 1 - Pick Kit	1 pcs		12/20/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		DAS
							Packaging 1 - 3		69
							Packaging 1 - 4		9-89
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		AUG 21 2020
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		

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Container No: S295483

Part: 6F9540V00231

Job No: 197321

Serial No/Batch: S295433

Revision: D

Inspector:

Exp Date:

Instructions:

Date: 08/21/20

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105 QC 4	1 pcs	12/20/19	0.00 0.00	Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
				QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	
120 Packaging 3-1 - Stock - B4B	1 pcs	12/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
125 DC - 1 - B4B	1 pcs	12/20/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
130 QC 21 - FG	1 pcs	12/20/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - FG - 53	

DAS
72
9-89

AUG 2 1 2020

DAS
72
9-89

AUG 2 1 2020

DAS
21
9-89

AUG 2 1 2020

DAS
21
9-89

AUG 2 1 2020

Part Op 100 - (Pick Kit)

Descriptions: 105 - (QC4- 100% Inspect kits for completeness)

120 - Identify and pack for shipping as per PPP 6F9540V00231

125 - Photocopy blue file per PPP D169-841-015 chg002 and create labels per 6F9540V00231 CHG002

130 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D169-841-015	AW169 Lower Cutter	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	5244829
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Packaging 1 - Pick Kit	D169-841-015	1	0	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		Other/Details: _____ 			



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ENGINEERING CHANGE REQUEST

ECR 21

Date Opened: 7/2/19 3:01 PM
Type: Drawing/Pattern Change
Priority: High
Status: Complete
Reason: Update Supplier Material Update drawing with manufacturing Issues
Expense: 1000
Target Date:
Execution Date:
ECR Approval No: HB ECN20-21

Requested By: Drouin, Steven
Requester*: Lavoie, Chantal
DE Approver*: Shepherd, David
ECR Lead*: Drouin, Steven
Responsible Engineer: Drouin, Steven

RE (R&D):
Status Note:

****BRIEF DESCRIPTION**:** 169 Cable Cutter System Drawing Change

DESCRIPTION/ ADR CONTENT:** Supplier obsoleted material, and we need to find a new supplier and material. The following drawings have been updated for manufacturability. 1.D4944 Rev.E: Gasket material update, and without holes. 2.D4857 Rev.G: Remove mounting holes per LHD request. 3.D4821 Rev.C: Update geometry and material callout 4.D4823 Rev B: Update grain direction and material callout 5.D4824 Rev B: Update grain direction and material callout 6.D4838 Rev.B: Update part numbers on sheet 1 to match model part numbers and add plate material option 7.D4842 Rev. C: Update dimensions, tolerances, and grain direction and add plate material option. Drawings are acceptable to Dart DE #02 David Shepherd. COMO-D169-841-1 Rev A was submitted to Leonardo to substantiate the changes. DDS-169-841 was updated to Rev D to include the latest revision of the aforementioned drawings and signed by Leonardo. Reference to CAR18-255, CAR18-218 & CAR19-326 With this update, parts no longer need a Concession to Leonardo before leaving the Hawkesbury facility Conclusion: Release D4821 Rev C, D4823 Rev B, D4824 Rev B, D4838 Rev. B, D4842 Rev. C, D4944 Rev. E, and D4857 Rev. G per ECN19-802 Kit has been updated as per DDS-169-841 Rev 2 Issue D to PN D169-841-011 to CHG 004 PN D169-841-013/-015 to CHG 003

CUSTOMER APPROVALS

Customer	Customer Visible	Customer Approval Required	*	Customer Approved
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ATTACHMENT PAGES

Document Name	Document Note
D4944	

PARTS

Part No	Rev	Part Status	Name	Type	Customer Part	Special Comments	Documents
D4821-1		Active	Windshield Deflector	Sub-assembly	D4821-1		D4821-RevC.pdf
D4823-1		Active	Upper Cutter Deflector	Sub-assembly			D4823-RevB.pdf
D4824-1		Active	Upper Cutter Mount	Sub-assembly			D4824-RevB.pdf
D4838-1		Active	Upper Cutter Body, LH	Sub-assembly	D4838-1		D4838-RevB.pdf
D4838-2		Active	Upper Cutter Body, RH	Sub-assembly	D4838-2		D4838-RevB.pdf
D4842-041		Active	Lower Cutter Assembly	Sub-assembly	D4842-041 D4842-041		URF 16-692-(841).pdf D4842-RevC.pdf
D4842-1		Active	Lower Cutter Deflector	Sub-assembly			D4842-RevC.pdf
D4842-3		Active	Lower Cutter Body, LH	Sub-assembly			URF 16-692-(841).pdf D4842-RevC.pdf
D4842-4		Active	Lower Cutter Body, RH	Sub-assembly			URF 16-692-(841).pdf D4842-RevC.pdf
D4857-041		Active	Wiper Deflector Assembly	Sub-assembly	D4857-041		URF 18-746-(841,1005).pdf
D4857-043		Under Review	Wiper Deflector Assembly, LH	Sub-assembly	D4857-043		URF 18-746-(841,1005).pdf
D4857-044		Under Review	Wiper Deflector Assembly, RH	Sub-assembly	D4857-044		URF 18-746-(841,1005).pdf
D4944-1		Active	Gasket	Sub-assembly			D4944-RevE.pdf

INVENTORY DISPOSITION

Part No Revision	Material No	Current Inventory Qty	Purchasing On-Order Qty	Qty Scheduled for Production
D4821-1		24 Use as is	0 *	0 No Changes To Jobs
D4823-1		18 Use as is	0 *	0 *
D4824-1		14 Use as is	0 No Release Changes	0 No Changes To Jobs
D4838-1		15 Use as is	0 *	0 *
D4838-2		17 Use as is	0 *	0 *
D4842-041		1 Use as is	0 *	6 No Changes To Jobs
D4842-1		8 Use as is	0 *	6 No Changes To Jobs
D4842-3		14 Use as is	0 *	0 *
D4842-4		14 Use as is	0 *	0 *
D4857-041		14 Use as is	0 *	20 No Changes To Jobs
D4857-043		1 Use as is	0 *	0 No Changes To Jobs
D4857-044		1 Use as is	0 *	0 *
D4944-1		24 Use as is	0 *	16 No Changes To Jobs

ACCOUNTING JOBS

Accounting Job No	Type	Group	Status
SE CAD 841	Sustain Engineering		Active

EFFECTS

Effect Group	Effects
2. ECR Lead Assessment - Impacted Docs & Output	Drawing Change Required (1.D4944 Rev. E: 2.D4857 Rev. G: 3.D4821 Rev. C: 4.D4823 Rev. B: 5.D4824 Rev. B: 6.D4838 Rev. B: 7.D4842 Rev. C:), Other Documents (Document N#: COMO-D169-841-1 Rev.A Document N#: DDS-169-841 Issue D)
3. ECR Lead Assessment - Status During ECR	UR - Full Under Review (See Section 2 for list of parts)
4. Production Type	In-house production
5A. ECR Lead Assessment - MINOR Changes	Correction of drawing errors (Grain Direction Material)
6A. Production Impact	New Purchased Part Required (M-SIL20-S.125 for D4944 Rev. E)
7. Final Impacts	Paperwork Update (See section 2), Parts Must Comply (Make sure all part are to the proper Rev), Close quality documents (NCR,CAR,PAR,CIR) (Reference to CAR18-255, CAR18-218 & CAR19-326), Quality Special Action (Verify all parts in stock to have the correct rev's per ECR 21)
9. Sustaining Cost Grouping	Manufacturing Improvement